

Fig. 1
PRIOR ART



Fig. 2

## **PRIOR ART**

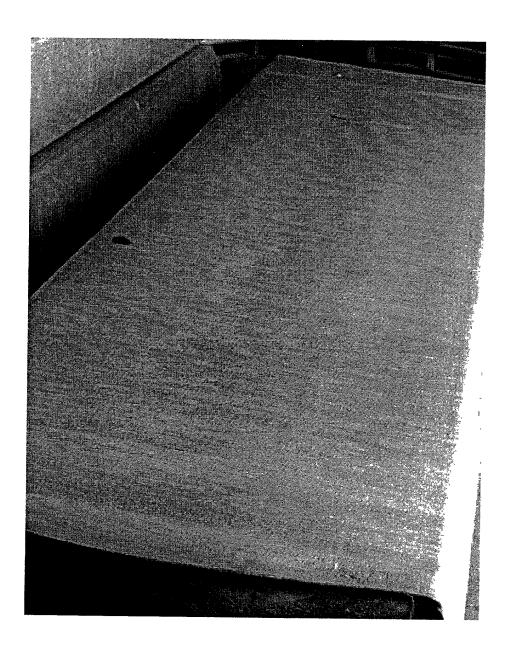


Fig. 3

PRIOR ART

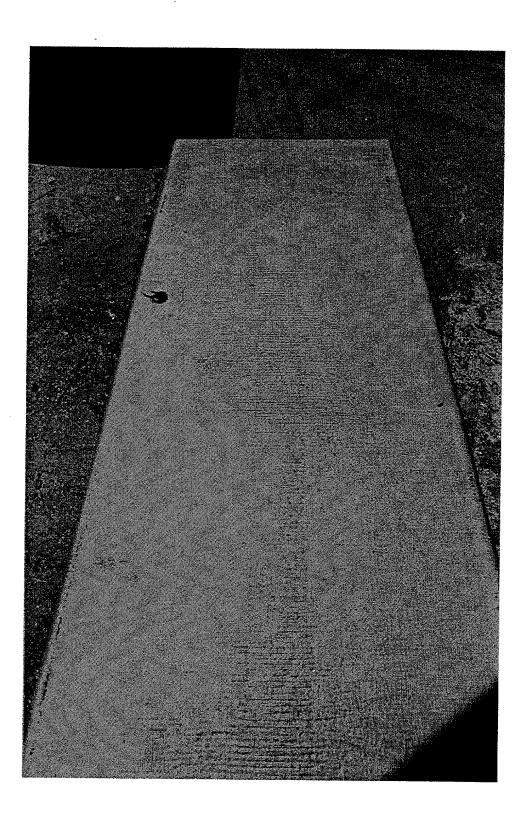


Fig. 4

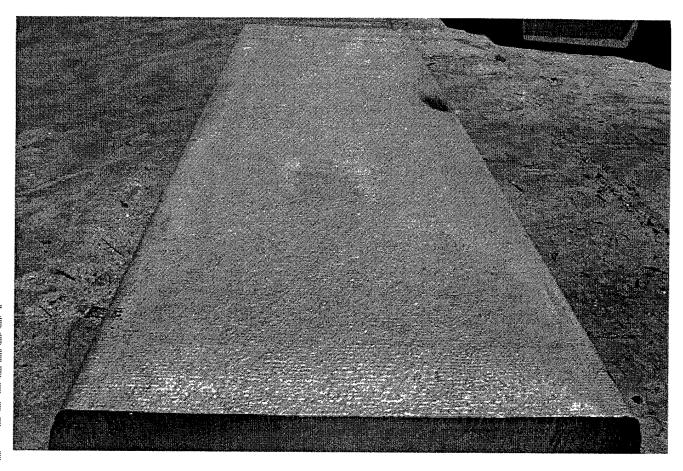


Fig. 5

Effect of Calcium on 7050 Ingot Cracking - No Beryllium

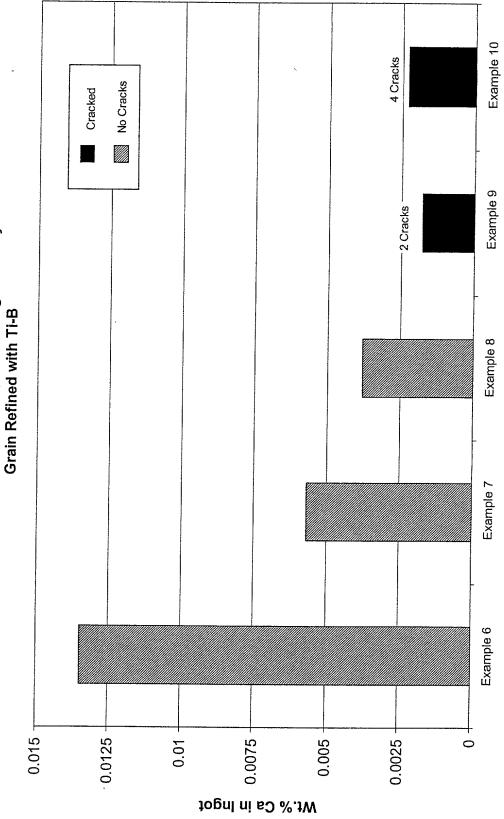


Fig. 6a

Example 26 No Cracks Example 5 Cracked Example 23 Example 18 3 Cracks Effect of Calcium on 7050 Ingot Cracking - No Beryllium 2 Cracks Grain Refined with Ti-C Example 21 Example 22 1 Cracks 1 Cracks No Cracks, but had folds Example 20 Example 19 No Cracks, but had folds Example 18 0.0000 0.0100 0.0075 0.0150 0.0125 0.0050 0.0025

Wt.% Ca in Ingot

Fig. 6b

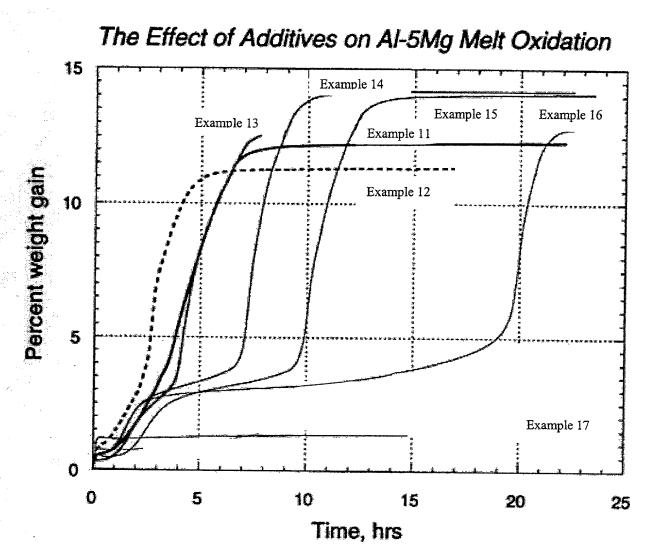


Fig. 7